



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 84747

\*84747\*

Page 2

May-22-12 2:59:25 PM

Item ID: D3898-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Floor Protector (206L)

Start Date: 22/05/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 05/06/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

\*110\*

Thermoform

Thermoforming Machine

Memo

0.00

1-Machine Set-Up

2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9501

Dwg Rev:   A  Folio Rev:   A  

1 2 B12/06/18

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Quality Control

Memo

0.00

Visually inspect part for proper formation and texture

1 2 B12/06/18

- P.I.D.

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Quality Control

Memo

0.00

① B12/06/18  
12/06/18

W/O: 84747		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3898-1 PAR #: \_\_\_\_\_ Fault Category: Hemifin NCR: Yes No DQA: dat Date: 12/6/20  
 Resolution: SCAN Disposition: SCAN QA: N/C Closed: off Date: 12/6/27

NCR: 12.1534		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/18	110	WRINKLES IN FINISHED PART RL temp	S 12/06/20 057042	Very Hot & Humid Reduce heat. Scrap & replace 1 part	DL 12/06/18	S 12/06/20	S 057042 12/06/20	S 12/06/20
12/06/18		WRINKLE IN FINISHED PART RL temp	S 12/06/20 057042	STILL TOO HOT Reduce heat again Scrap & replace 1 part	DL 12/06/18	S 12/06/20	S 12/06/20 057042	S 12/06/20
			LLB 12/06/27 057042				LLB 12/06/27 057042	

NOTE: Date & initial all entries

# Work Order ID 84747

May-22-12 2:59:25 PM

**\*84747\***

Page 3

Item ID: D3898-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Protector (206L)

Start Date: 22/05/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 05/06/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00

**\*140\***

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

12/06/20

150

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*150\***

QC

Memo

0.00

Quality Control

Complete FAI document

12/06/20

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

5/24/20

12/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 84747

\*84747\*

Page 4

May-22-12 2:59:25 PM

Item ID: D3898-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Floor Protector (206L)

Start Date: 22/05/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 05/06/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: Date: Tooling: Date:

Stop \*NR2\*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170	Identify as per dwg & Stock Location:	0.00							
-----	---------------------------------------	------	--	--	--	--	--	--	--

\*170\*

Packaging

Memo

POP 85031

0.00

Packaging

180	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

\*180\*

QC

Memo

0.00

Quality Control

*[Handwritten signature]*

12/6/25 *[Handwritten signature]*

MCS 12/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

May-22-12 2:59:29 PM

Page 1

Work Order ID: 84747

\*84747\*

Parent Item: D3898-1

\*D3898-1\*

Parent Item Name: Floor Protector (206L)

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev.A New Issue 09/02/06 DL

IPP RevB

Add Step 105 Dry Material 10/04/21 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	1,181.636	10.6	22.31579			

\*MI FXS 118-90318-08\*

\*\*

Lexan Sheet

Location

therm

Loc Qty

1181.636941

1181.63694

Loc Code

113127

23.48

PT

12/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	89777
<b>Description:</b> Floor Protector		<b>Part Number:</b>	D3898-1
<b>Inspection Dwg:</b> D3898	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b>	BB	<b>Date:</b>	12/06/18
---------------------	----	--------------	----------

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	Min	.56	✓			
1.00	Min	1.06	✓			
5.6	+0.2/-0.0	5.6	✓			
0.080	Min	.083	✓			
0.050	Min	.095	✓			

<b>Measured by:</b>	BB	<b>Date:</b>	12/06/20
<b>Audited by:</b>	8	<b>Date:</b>	12/06/20
<b>Prototype Approval:</b>	N/A	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	11

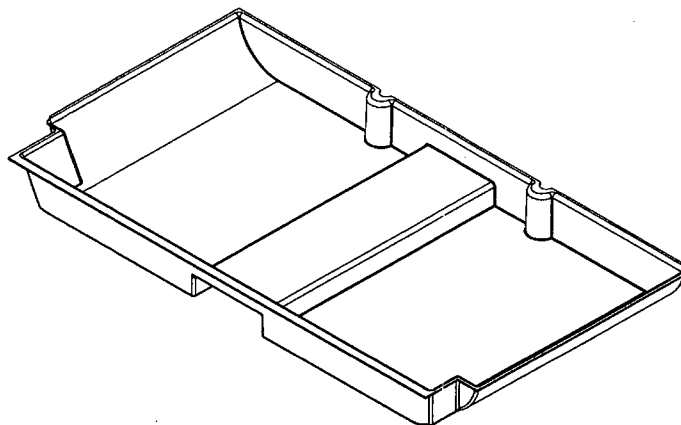
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3898-1 FLOOR PROTECTOR (206L)**

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 84747 *MLJ*

*12/05/22*

**RELEASED**  
*29/06/28 MLJ*

**NOTES:**

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3898-1" USING VIBRATING STYLUS
- 7) WEIGHT: 5.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9501 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A		NEW ISSUE		PH		09.02.27					
REV.		DESCRIPTION				BY		DATE			
DESIGN		PH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
DRAWN		PH									
CHECKED		SL		DRAWING NO.		REV. A					
MFG. APPR.		SL		D3898		SHEET 1 OF 2					
APPROVED		SL		TITLE		SCALE					
DE APPR.		SL		FLOOR PROTECTOR (206L)						NTS	
DATE		09.02.27		COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>							

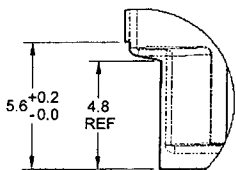
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

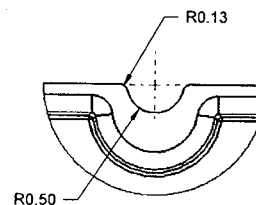
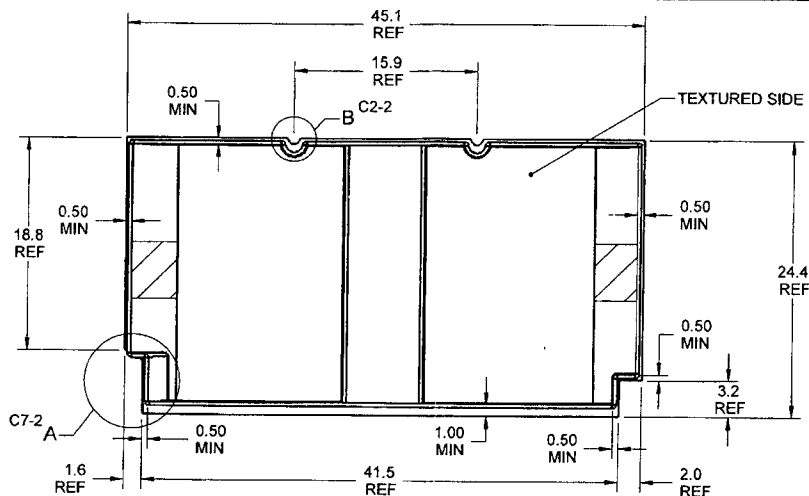
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

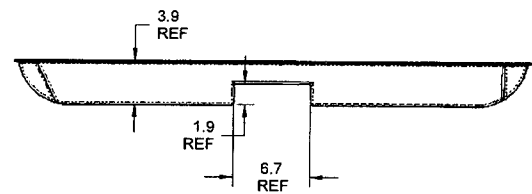
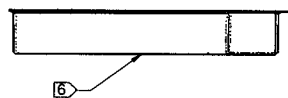
**NOTE:** Date & initial all entries



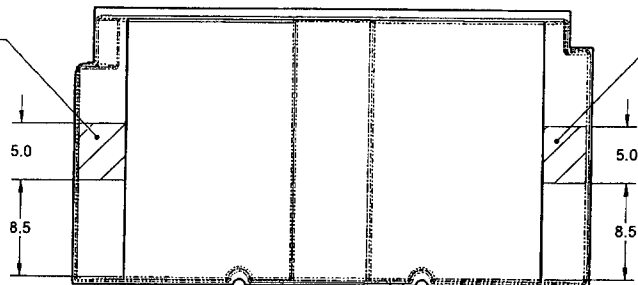
**DETAIL A** C6-2  
SCALE 2X



**DETAIL B** D5-2  
SCALE 5X  
2 PL



MIN THICKNESS  
0.080  
(SHADED REGION)



MIN THICKNESS  
0.080  
(SHADED REGION)

**D3898-1 FLOOR PROTECTOR (206L)**

**RELEASED**  
09/06/07

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3898</b>	REV. A
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		<b>FLOOR PROTECTOR (206L)</b>	NTS
DATE	09.02.27	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries